

Work Order ID 84294

Wednesday, May 09, 2012 10:54:58 AM

Blue

84294

Page 1

Item ID: D206-642-311BL Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube LH
 Start Date: 5/9/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/18/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-05-09 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-642	Rev N

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-311 CHG006								

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS 16 12/12/26 JB

12/12/25 12-7-25

12/12/25 ①

DAS 16 12/12/26

⑦

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, May 09, 2012 10:54:58 AM

Item ID: D206-642-311BL Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH
 Start Date: 5/9/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/18/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-311								
	Location: _____								
	PPP Rev: <u>F</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

K *SP*
12-7-26
12/17/30
mf
12-07-29

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J05.10.11Added D3429-1 per CHG004KJ/CP/JLM/EC
IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec
IPP Rev:L 08-09-29 as per DSI9421 DD verified by:EC IPP Rev:M as per REV.N DD
10.04.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	0	84294			

Location Loc Qty Loc Code

FG -1
FG081 2
57156 0
57160 0
57161 0
69950 1
FG082 2
36550 1
69952 1

~~D206-648-013~~ CHG7002
GHW Modification

ATTN: D3414-041 - BLUE

Manufactured No 110 Each 4.0000

Location Loc Qty Loc Code

FG120 2
65455 0
66633 0
81332 1
83040 1
FG125 2
83040 2

84295

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D2932-1 Manufactured No 110 Each 19.0000
Saddle LH Out, 206
BLUE

Location	Loc Qty	Loc Code
ST421	6	
81801	6	
ST428	13	
81620	7	
83413	6	

1 ✓ JB

D2933-1 Manufactured No 110 Each 16.0000
Saddle LH In, 206
BLUE

Location	Loc Qty	Loc Code
ST421	6	
81803	6	
ST428	10	
75097	3	
81621	7	

1 ✓ JB

D2938-1 Manufactured No 110 Each 14.0000
Saddle LH Out, 206
BLUE

Location	Loc Qty	Loc Code
ST421	6	
81805	6	
ST428A	8	
78957	2	
83415	6	

1 ✓ JB

D2939-1 Manufactured No 110 Each 7.0000
Saddle LH In, 206
BLUE

Location	Loc Qty	Loc Code
ST428A	7	
74607	1	
78956	1	
82132	5	

1 ✓ JB 12/07/25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

8 AN3-41A Bolt Purchased No 110 Each 473.0000 8 8 JB

Location	Loc Qty	Loc Code
ST354	473	
120498	123	
121162	150	
121243	200	

8 D2652 Bushing Manufactured No 110 Each 200.0000 16 8 JB

Location	Loc Qty	Loc Code
FG	44	
31985	44	
ST013	156	
73836	36	
81951	61	
81952	59	

8 MS21042L3 Nut Purchased No 110 Each 2,930.0000 8 8 JB

Location	Loc Qty	Loc Code
ST300	2930	
117885	32	
119017	1117	
119075	138	
121349	656	
121444	987	

8 AN260JD10 Washer NAS1149D0363J Purchased No 110 Each 0.0000 8 8 JB 12/14/44 12/524 JB 12/07/25

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-10A
Bolt

Purchased No

110 Each 280.0000

4 122131 4 ✓ JB

Location

Loc Qty

Loc Code

ST337

280

118191

80

120717

50

121181

50

121243

100

AN5-11A
Bolt

Purchased No

110 Each 517.0000

4 119573 4 ✓ JB

Location

Loc Qty

Loc Code

ST337

517

118191

13

119512

504

AN960JD516
Washer

NAS1149D0563J

Purchased No

110 Each 0.0000

119573
8 119548 ✓

AN4-6A
Bolt

Purchased No

110 Each 1,830.0000

12 119246 12 ✓ JB

Location

Loc Qty

Loc Code

355

500

121631

500

ST356

1330

119017

830

121243

500

119017

AN960JD416
Washer

NAS1149D0463J

Purchased No

110 Each 30.0000

25 122441 25 ✓ JB 12/07/25

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Nut

Purchased No

110 Each 5.208.0000

12

12

Location

Loc Qty

Loc Code

ST300

5208

119075

241

121011

1687

121444

2980

121652

300

121444

D3407-043

Tow Ring

BLUE

Manufactured No

110 Each 15.0000

Location

Loc Qty

Loc Code

ST420

2

79232

2

ST463

13

68339

2

77504

10

78841

1

79232

D3456-1

Washer

Manufactured No

110 Each 176.0000

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

169

80252

1

81876

68

83584

100

83584

D3457-1

Washer

Manufactured No

110 Each 37.0000

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

27

67779

1

81977

26

83268

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 6

Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-4
Nut

Purchased No

110 Each 1,666.0000

123452 JB

Location

Loc Qty

Loc Code

FG 40
104603 40
ST301 1626
119546 185
121162 941
121652 500

AN4C5A
BOLT

Purchased No

110 Each 208.0000

JB

Location

Loc Qty

Loc Code

ST355 208
112243 143
119017 65

AN960C416

NAS1149C0463R

Purchased No

110 Each 0.0000

119017
119097 JB

washer

D3413-1

Ring

BLUE

Manufactured No

110 Each 62.0000

86562 JB 12/07/22

Location

Loc Qty

Loc Code

ST420 5
79233 5
ST464 57
76754 9
80224 7
83307 41

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 09, 2012 10:54:57 AM

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Work Order ID: 84294

Parent Item: D206-642-311BL

Parent Item Name: Skidtube LH

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D2712
Set Screw

Manufactured No

110 Each 683.0000 10 10 ✓ JB

Location

Loc Qty

Loc Code

FG	50	
29962	50	
ST017	633	
79585	183	
81871	200	81871
83559	250	

S D2934
Saddle Spacer

Manufactured No

110 Each 6.0000 2 2 ✓ JB

Location

Loc Qty

Loc Code

FG	6	
31929	6	

S D2935
Saddle Spacer

Manufactured No

110 Each 34.0000 2 2 ✓ JB 12/07/25

Location

Loc Qty

Loc Code

FG	6	
31793	6	
ST021	28	
78807	28	78807

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-347	WEARSHOE KIT (REPLACES -343)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8				1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D3535-11	WEARSHOE (REPLACES D2656-11)
22B					1	1				D3536-11	GASKET
23A					1	1				D3535-23	WEARSHOE (REPLACES D2656-23)
23B					1	1				D3536-23	GASKET
24A					1	1				D3535-35	WEARSHOE (REPLACES D2656-35)
24B					1	1				D3536-35	GASKET
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1	1	1						D3456-1	WASHER
32	1	1	1	1						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: 0

Date: 11.06.15

DART AEROSPACE USA, INC.

IIN-D206-642

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ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -347	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
50							1	1		D4364-041	FWD WEARPLATE ASSY
51							1	1		D4364-043	AFT WEARPLATE ASSY
52							18	18		D3873-1	BUSHING
53							4			D2649	SPACER
54A							9	9		AN3-36A	BOLT
54B							9	9		NAS1149C0332R	WASHER (OR AN960C10L)
54C							9	9		MS21042-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D2650-5 OR D4361-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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